

Date: Monday, 3/26/2007 3:22:54 PM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : ARM |
| Job Number | : 31481 | | |
| Estimate Number | : 10705 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D2012101 |
| This Issue | : 3/26/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D2012 REV C |
| Prsht Rev. | : NC | Project Number | : <i>N/A</i> |
| First Issue | : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision | : C |
| Previous Run | : 30297 | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 4/8/2007 |
| Checked & Approved By | : <i>[Signature]</i> | Qty: | 10 Um: Each |
| Comment | : Est Rev:1 02.04.03 Added Inspect level 3 NG | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0500W035 | 304 RD Tube .500 x .035W |
|-----|----------------|--------------------------|



Comment: Qty.: 2.1000 f(s)/Unit Total : 21.0000 f(s)
Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)
Identify as D2012-101
Batch: *M103453 x5 / M103869 x5*

FF 07-04-05 10

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

1-Punch to length as per Dwg D2012-101 & template D2012-101T1

FF 07-04-05 10

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

FF 07-04-05 10

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L 07/04/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/09/14
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:22:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 31481

Part Number: D2012101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 6/7/11 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten: 7/4/10 59

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 07/04/11 (10)

Job Completion



Handwritten: u 07/04/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

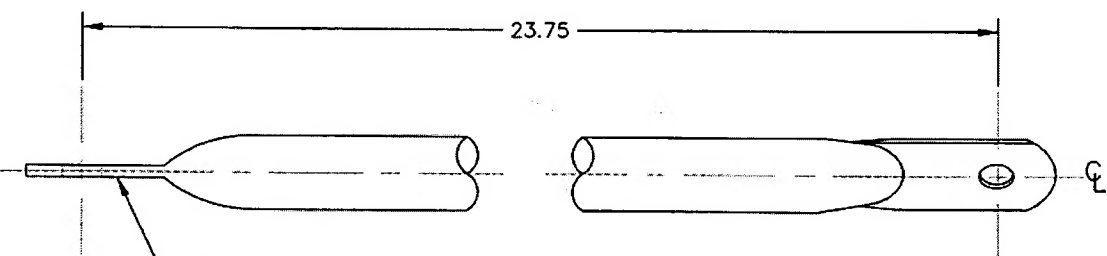
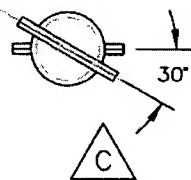
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| DESIGN | | DRAWN BY | | DART AEROSPACE LTD | |
|----------|----------|---|--|-----------------------------|--|
| JB | | 1P | | HAMKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | | REV. C | |
| | | D2012-101 | | SHEET 1 OF 1 | |
| DATE | | TITLE | | SCALE | |
| 02.03.26 | | ARM | | NTS | |
| A | 92.06.04 | NEW ISSUE - DRAWN FROM D2012 | | | |
| B | 98.04.28 | ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD | | | |
| C | 02.03.26 | ADD FINISH: CHANGE ANGLE TO MATCH B15015 PER NCR 641 | | | |

RELEASED
02.03.26PUNCH BOTH ENDS PER SPEC
CONTROL DRAWING D2727**NOTES:**

1. MAKE PER TEMPLATE DT8067 (WAS DT2012-101)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\varnothing 0.500 \times 0.035$ WALL
3. FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31481